Quality Control

Memo

Page 1

Monday, December 06, 2010 10:15:26 AM Accept Item ID: D3407-3 Setup Start Ravision ID: Stop Item Name: Stem **Start Qty: 16.00** Start Date: 12/6/2010 **Cust Item ID: Required Date: 12/13/2010** Req'd Qty: 16.00 **Customer:** Reference: Start Run Process Plan: W Date: 10-12-0b. Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Insp. Work Center ID Description Qty Otv Code Stamp **Run Hours** Number Revision Nbr Draw Nbr D3407 Rev E 100 · 0.00 DOOSAN LATHE Doosan Doosan Lathe 110 QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo **Quality Control** 120 QC8- Inspect parts - second check 0.00

space Lid		WORK ORDER	CHANGES		·····		
TEP	PR			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _	
Resolution:		Disposition:	QA: N/C	Closed:		Date: _	
	TEP	TEP PRO	WORK ORDER OF TEP PROCEDURE CHANGE PAR #: Fault Category:	WORK ORDER CHANGES TEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Ye	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date Qty	WORK ORDER CHANGES TEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

NCR:		W	E (NCR)					
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
*	+	15 g		,				
		Co. Alexandra						
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NOTE: Date & initial all entries

Work Order ID 64436

Monday, December 06, 2010 10:15:26 AM



Page 2

Item ID:

Revision ID:

D3407-3

Stem

Item Name:

Start Date:

Required Date: 12/13/2010

12/6/2010

Start Qty: 16.00 Req'd Qty: 16.00

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:_

Tooling:

Set Up/

SPC (Y/N):

Tool ID

Date:

Tool # Plan

Code

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Run Hours

0.00

0.00

0.00

0.00

Memo

QC21- Final Inspection - Work Order Release

QC

140

Quality Control

Memo

Reject Accept Qty Qty

Reject

Insp. Number Stamp

11/02/23 De) MF 11-02-27

Dart Aerospace Ltd

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

	·- V	VORK ORDI	ER NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	
DATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Section B Section B Verification Approval Chief Eng

NOTE: Date & initial all entries

Work Order ID: 64436

Parent Item: D3407-3

rarent Item Name: Stem



Start Date: 12/6/2010

Required Date: 12 13/2010

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A□05.10.18□New issue□KJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased	No			100	f	17.1950	0.366	6.164211	11):	2/1	4

17-4 round bar .750

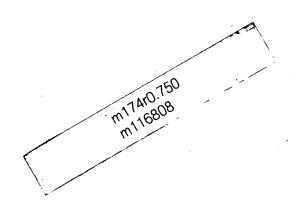
 Location
 Loc Qty
 Loc Code

 MAT
 17.195

 114488
 17.195

116808

6.1 Pt



Dart Ae	rospace	Ltd								y .
W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			ha.							
		<u></u>								
			*							
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	A:	_ Date: _	
	Re	solution:	Disposit	ion:	QA	QA: N/C Closed: Date: _			·	
NCR:		V	VORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NČ Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
										1
										-

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 6	436
Description: Stem	Part Number:	D3407-3
Inspection Dwg: D3407 Rev: E	P	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

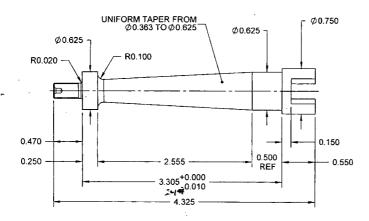
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	,063				
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265				
Major Ø	Max: 0.249 Min: 0.2425	.246				
Ø0.625	+/-0.010	,624			,	
Ø0.363	+/-0.010	, 364	/-			
Ø0.750	+/-0.010	,750				
R0.100	+/-0.010	R.100	//	,		
0.470	+/-0.010	.468				
0.250	+/-0.010	. 286				The state of the s
2.555	+/-0.010	2-550	1			
3.305	+0.000/-0.010	3.300	/		,	
4.325	+/-0.010	4.325			Vela	212
0.150	+/-0.010	(<)	-/			
0.550	+/-0.010	-356	///			
0.625	+/-0.010	-625	-/			
0.250	+0.010/-0.000	-255	//			

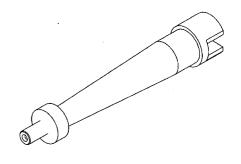
Measured by:	Audited by:	SL.	Prototype Approval:	N/A
Date: 11/2/11	Date:	11/02/22	Date:	N/A

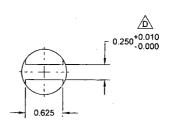
Rev	Date	Change	Revised by Appro	ved
Α	06.11.08	New Issue	KJ/JLM	
В	07.09.26	Tolerances revised	KJ/EC	
С	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM 1.0	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD 🖟	

0.063 REF CENTER DRILL #2 0.125 DP 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A













DESIGN	(g)	DART AEROSPA	DART AEROSPACE USA, INC.			
DRAWN	Pet	PORT HADLOCK, WA				
CHECKED	5 /	DRAWING NO.	REV. E			
MFG. APPR.	Chil	D3407	SHEET 3 OF 5			
APPROVED	1111	TITLE	SCALE			
DE APPR.		TOW RING	NTS			
DATE 08.0	07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND COMPENTAL AND IS SUPPLIED ON THE EXPRESS CONGRITO HALT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPENDENTE TO DAY OF OTHER PERSON WITHOUT				

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NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.27 lbs

8

6